

# Work Order ID 59337

Tuesday, June 01, 2010 2:50:34 PM



Page 1

Item ID: D3913-1

Accept



Setup Start



Revision ID:

Item Name: Rib

Stop



Start Date: 6/1/2010 Start Qty: 3.00



Cust Item ID:

Required Date: 6/7/2010 Req'd Qty: 3.00



Customer:

Reference:

Approvals:

Process Plan:

*HA*

Date: *10-6-01*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3913	A

100 0.00



Large Fab

Memo

0.00

Large Fab

- 1- Cut tube as per dwg D3913
- 2- Drill hole as per dwg \*\*\*one side only\*\*\*
- 3- remove identification marks and deburr

*SAD 10-06-10*

*3*

110 QC5- Inspect part completeness to step on W/O 0.00



QC

Memo

0.00

Quality Control

*S w l o c h*

*x3*

120 Identify as per dwg & Stock Location: *WA* 0.00



Packaging

Memo

0.00

Packaging

*SAD 10-06-017*

*3*

**Work Order ID 59337**

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Page 2

Item ID: D3913-1

Accept



Setup Start



Revision ID:

Item Name: Rib

Stop



Start Date: 6/1/2010 Start Qty: 3.00



Cust Item ID:

Required Date: 6/7/2010 Req'd Qty: 3.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/06/15 *[Signature]*  
MF  
10-6-14

# Picklist Print

Tuesday, June 01, 2010 2:50:37 PM

Page 1

Work Order ID: 59337

Parent Item: D3913-1

Parent Item Name: Rib

Comments: IPP Rev:A new issue DD 10.03.19 verified by:EC  
add drill one side only DD 10.04.12 verified by:EC



IPP Rev:B

Start Date: 6/1/2010

Required Date: 6/7/2010

Start Qty: 3.00

Required Qty: 3.00

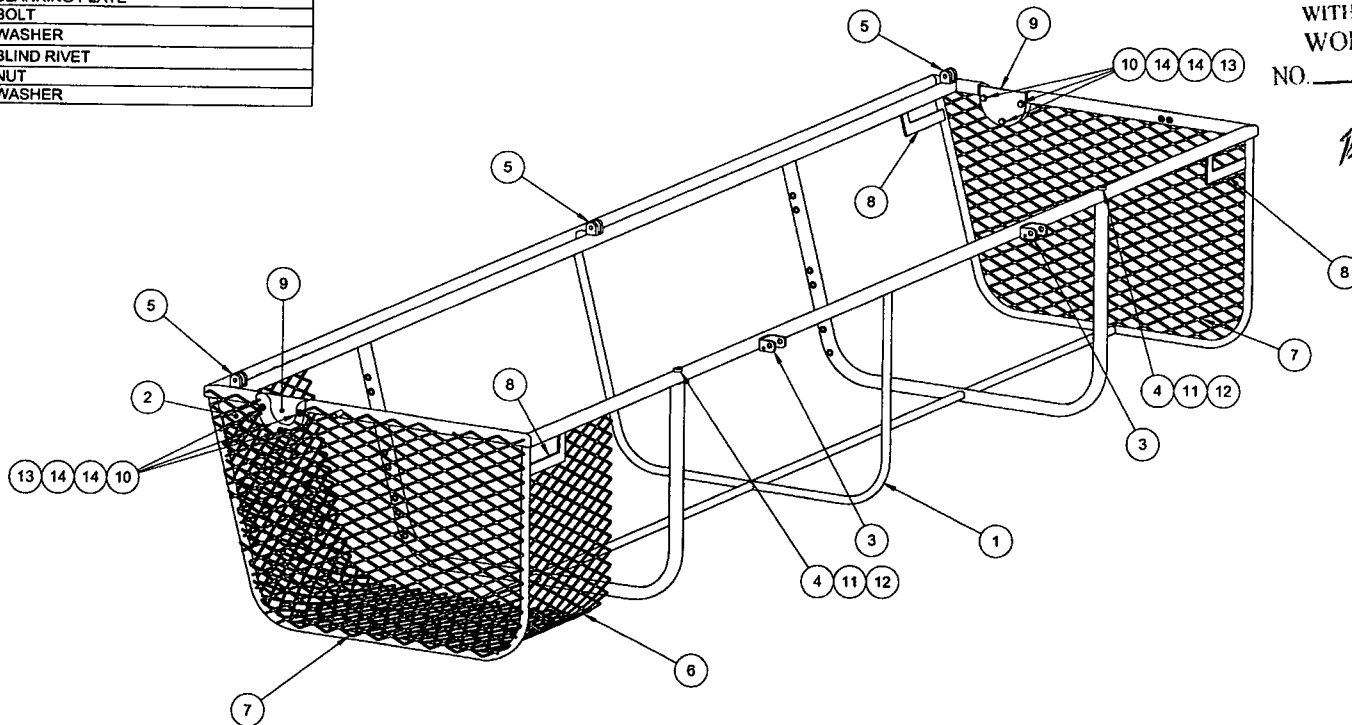
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304TS0.750W.049		Purchased	No			100	f	100.5164	8	25.26316			
												SAO 10-06-10	
304-SQ Tube .75x.75x.049W													

Location	Loc Qty	Loc Code
MAT	100.5163789	
113763	0	
114323	33.2519289	
114677	67.26445	
MAT017	3.68448E-05	
114298	3.6845E-05	

M114835

~~25.2631~~

ITEM	QTY -041	P/N	DESCRIPTION
	X	D3913-041	LONG BASKET BASE ASSY (350)
1	1	D3913-101	TUBULAR ASSY (350 SHORT BASKET)
2	1	D3913-15	WIDE HANDLE PLATE
3	2	D2581	MOUNTING BRACKET
4	2	D2931	BUMPER
5	3	D4016-1	HINGE HALF, BASE
6	1	D4020-1	MESH (350 BASKET LONG BASE)
7	2	D4020-11	END MESH, BASKET
8	3	D4021-1	HANDLE PLATE
9	2	D4021-5	BLANKING PLATE
10	6	AN3-10A	BOLT
11	2	AN960JD8	WASHER
12	2	MS20600AD4W3	BLIND RIVET
13	6	MS21042L3	NUT
14	12	NAS1149F0332P	WASHER



**D3913-041 LONG BASKET BASE ASSY (350)**  
(MESH SHOWN LOCALLY FOR CLARITY)

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 43.3 lbs APPROX
- 8) INSTALL AFTER FINISH
- 9) MASK HOLES PRIOR TO POWDER COAT
- 10) WELD PER DART QSI 004

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 59337  
PHO-6-01

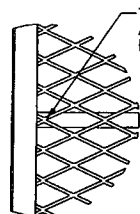
**RELEASED**  
2010-03-22  
JPH

REV.	DESCRIPTION	BY	DATE
A	NEW ISSUE	JPH	10.03.16
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DRAWN	JPH		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.03.16		

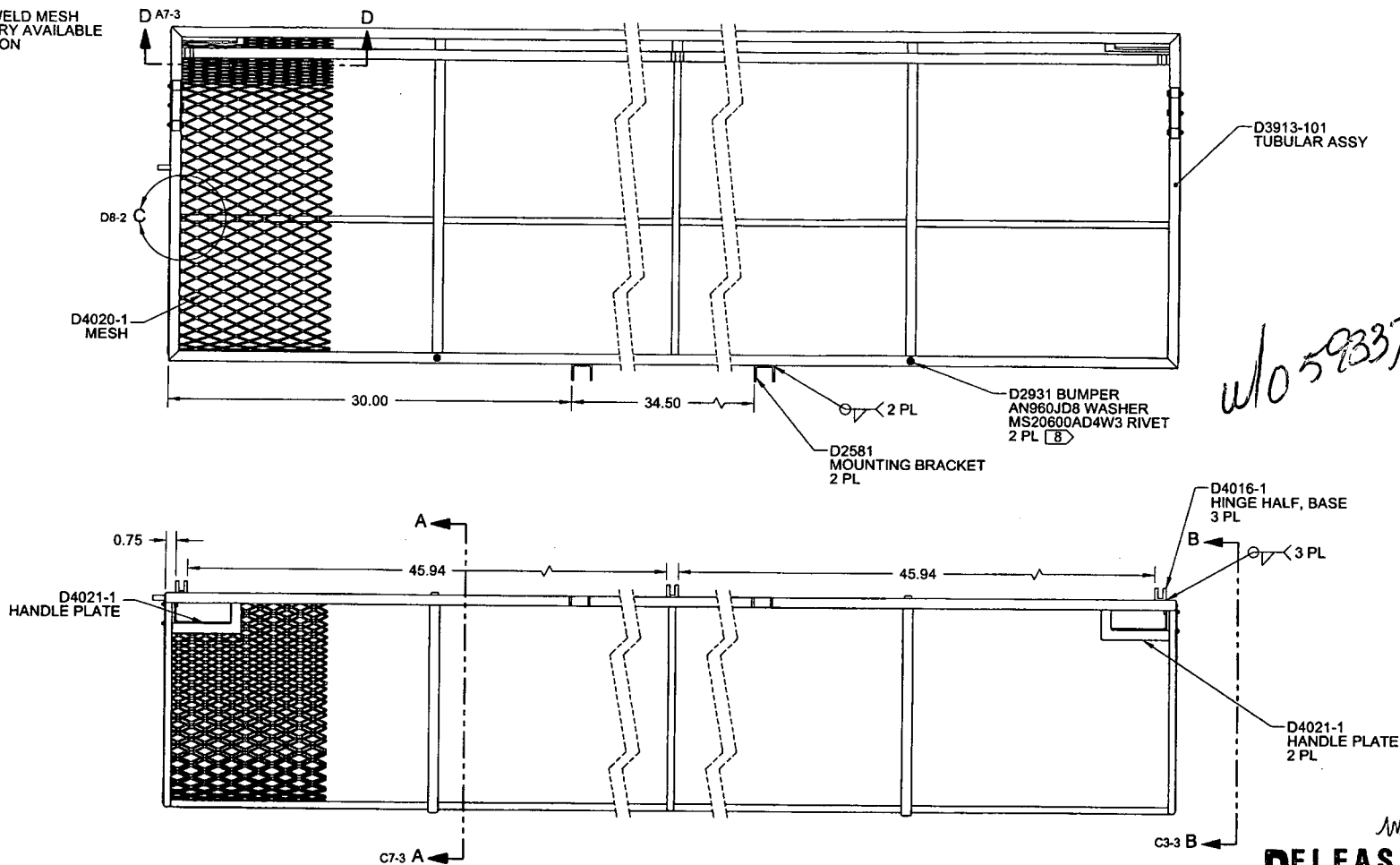
**DART AEROSPACE LTD**  
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3913** REV. A  
SHEET 1 OF 6  
TITLE **LONG BASKET BASE ASSY (350)** SCALE NTS

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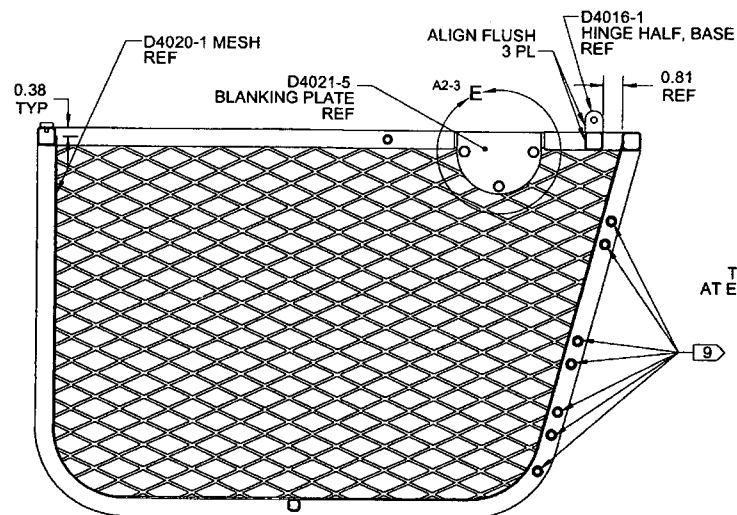
**DETAIL C** D7-2



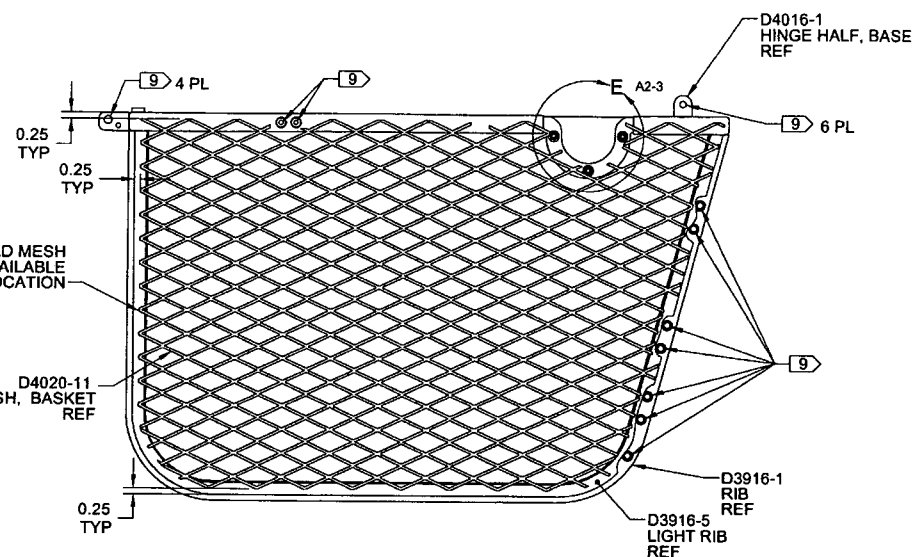
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(MESH SHOWN LOCALLY FOR CLARITY)

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2010-03-27

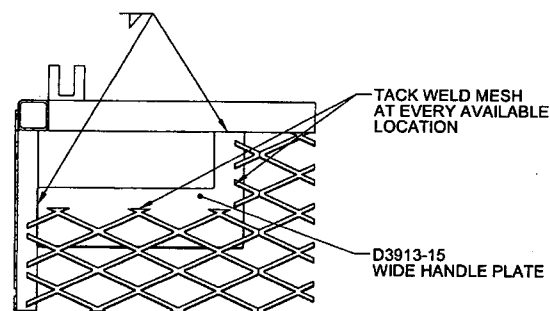
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DRAWN	JPH		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3913	SHEET 2 OF 6
APPROVED		TITLE	SCALE
DE APPR.		LONG BASKET BASE ASSY (350)	NTS
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**SECTION A-A** A5-2

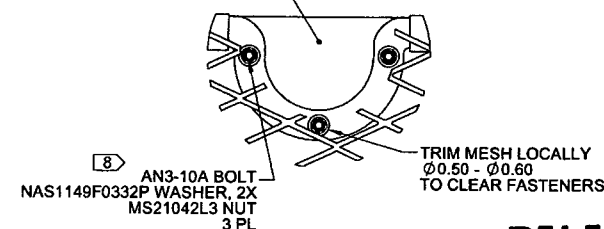


**VIEW B-B** A2-2



**SECTION D-D** D7-2  
TYPICAL FOR ALL  
HANDLE PLATES

**DETAIL** D2-3  
D6-3

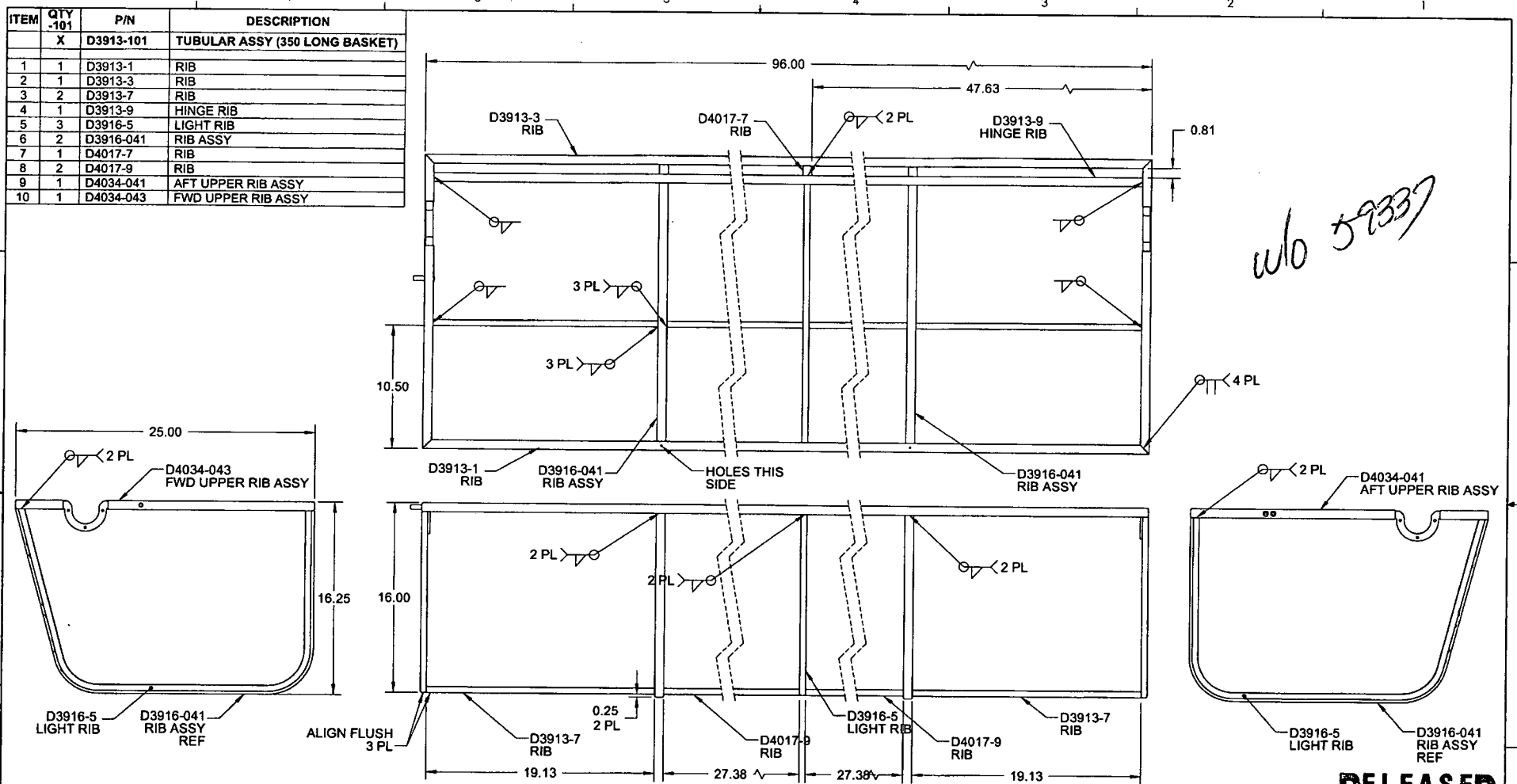


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APPROVED		TITLE <b>LONG BASKET BASE ASSY (350) NTS</b>
DE APPR.		SCALE
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ITEM	QTY	P/N	DESCRIPTION
	X	D3913-101	TUBULAR ASSY (350 LONG BASKET)
1	1	D3913-1	RIB
2	1	D3913-3	RIB
3	2	D3913-7	RIB
4	1	D3913-9	HINGE RIB
5	3	D3916-5	LIGHT RIB
6	2	D3916-041	RIB ASSY
7	1	D4017-7	RIB
8	2	D4017-9	RIB
9	1	D4034-041	AFT UPPER RIB ASSY
10	1	D4034-043	FWD UPPER RIB ASSY



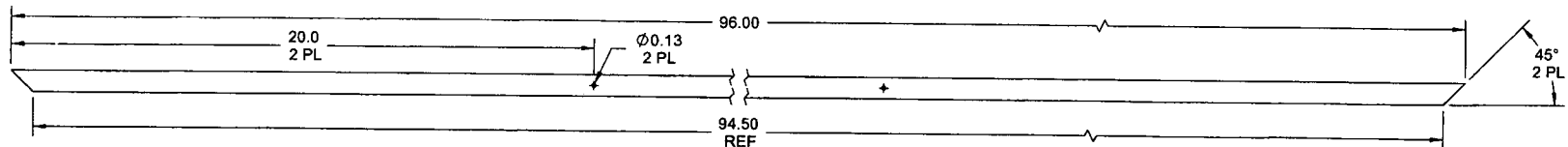
8 D3913-101 TUBULAR ASSY (350 SHORT BASKET)

NOTES:

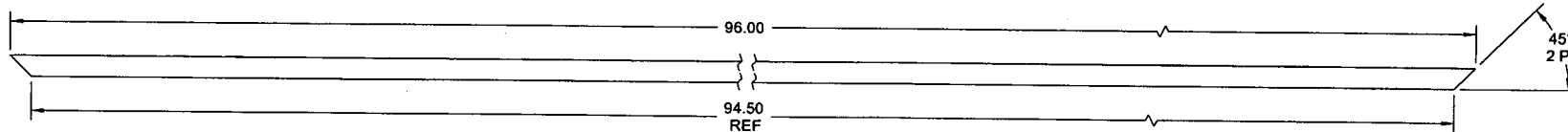
- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 22.53 lbs
- 8) TOLERANCE FOR XX.XX DIMENSIONS  $\pm 0.06$  FOR D3913-101
- 9) WELD PER DART QSI 004

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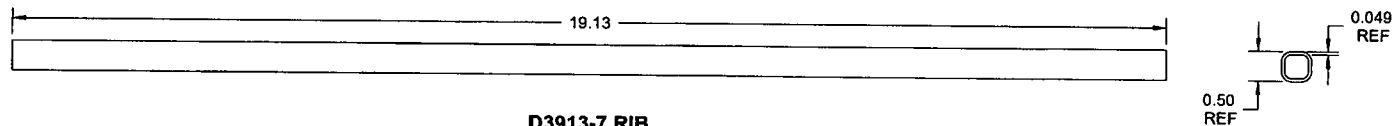
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2010-03-22



**D3913-1 RIB**



**D3913-3 RIB**



**D3913-7 RIB**



**D3913-9 HINGE RIB**

**NOTES:**

1) MATERIAL -1, -3, -9: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.049 WALL  
REF DART SPEC. M304TS0.750W.049

-7: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.50 X 0.50 X 0.049 WALL  
REF DART SPEC. M304TS0.500W.049

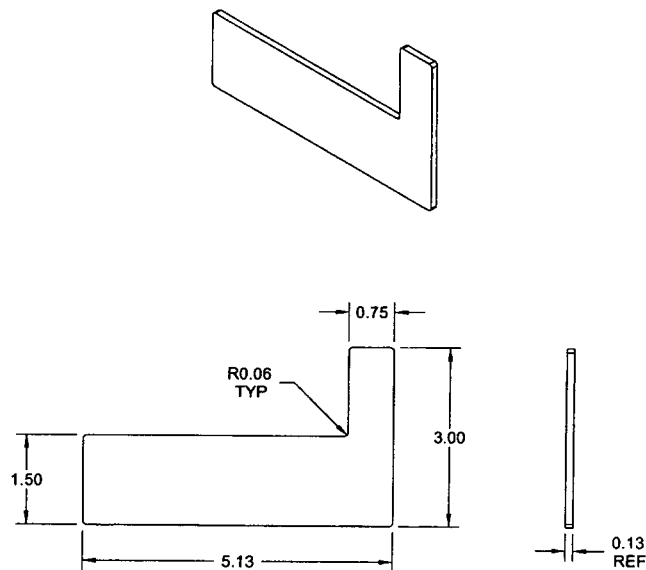
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: SEE ASSEMBLED WEIGHTS

*w/o 59337*

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**D3913-15 WIDE HANDLE PLATE**

**NOTES:**

- 1) MATERIAL: 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH,  
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240  
REF DART SPEC M304S11GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.31 lbs

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